

Work Order ID 56297

February 17, 2010 2:27:13 PM



Page 1

Item ID: D3303-041

Accept



Setup Start



Revision ID:

Item Name: Head Rest

Stop



Start Date: 2/17/10 Start Qty: 4.00



Cust Item ID:

Required Date: 2/17/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-2-17 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |

D3303

Rev B

100



Small Fab

Small Fab

0.00

Small Fab

Memo

0.00

1- Bond foam to D3303-043 bracket assembly as per Dwg D3303 using 3M 1300/1300L adhesive. Identify as D3303-041 A/R 3M 1300/1300L Adhesive Batch: M113174 2- Cover Head Rest with D3306-041 as per Dwg D3303

6/10/03/11 (4)

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/03/11

(4)

120



Packaging

Packaging

0.00

Memo

0.00

Identify with P/N and B/N, also identify the back of the headrest with TCCA-PDA # PDA04-11 using a permanent fine point marker as per Dwg D3303, then Stock Location: 186

6/03/11 (4)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 56297

February 17, 2010 2:27:13 PM



Page 2

Item ID: D3303-041

Accept

Revision ID:

Item Name: Head Rest

Start Date: 2/17/10 Start Qty: 4.00

Required Date: 2/17/10 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-05-22
MF
10-3-17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

February 17, 2010 2:27:17 PM

Page 1

Work Order ID: 56297

Parent Item: D3303-041

Parent Item Name: Head Rest

Comments: IPP: B ☐ 04.10.05 ☐ Revised Step 5 with headrIPP indentification ☐ KJ/JLM ☐

Start Date: 2/17/10

Required Date: 2/17/10

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

| | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|-----|------|--------|--------|--|--|--|
| D3303-043 | | Manufactured | No | | | 100 | Each | 1.0000 | 4.0000 | | | |
|-----------|--|--------------|----|--|--|-----|------|--------|--------|--|--|--|



Bracket Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

38968

1

1

100

Each

11.0000

4.0000



EP 10/03/11
B56751 (4x)

D3305-1



Cushion

Manufactured No

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

54440

54569

11

1

10

100

Each

12.0000

4.0000



EP 10/03/11
B54440 (4x)

D3306-041



Cover Assembly

Manufactured No

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

40910

Main Warehouse

ST232

54441

1

1

11

11

EP 10/03/11
4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

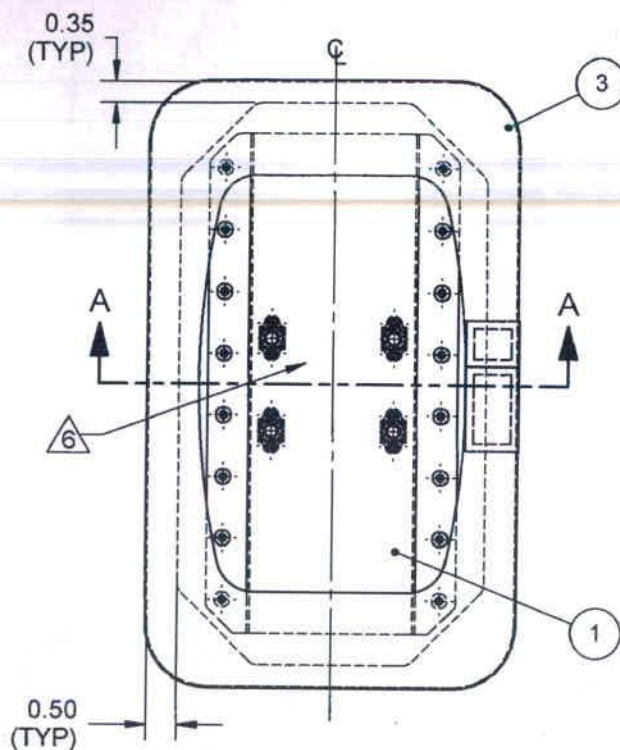
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

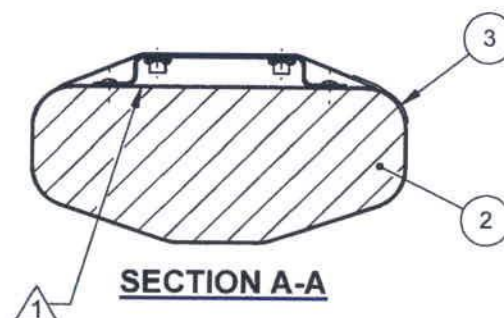
| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>PH</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>PH</i> | DRAWING NO. D3303 | REV. B SHEET 1 OF 4 |
| DATE 06.08.17 | | TITLE HEAD REST | SCALE 1:3 |
| REV | DATE | DESCRIPTION | |
| A | 04.08.18 | NEW ISSUE | |
| B | 06.08.17 | UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE | |



RELEASED

dc-09.19 *PH*

DEO ATTACHED

**D3303-041 HEAD REST**

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|------------------|
| | X | D3303-041 | HEAD REST |
| 1 | 1 | D3303-043 | BRACKET ASSEMBLY |
| 2 | 1 | D3305-1 | FOAM |
| 3 | 1 | D3306-041 | COVER ASSEMBLY |

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

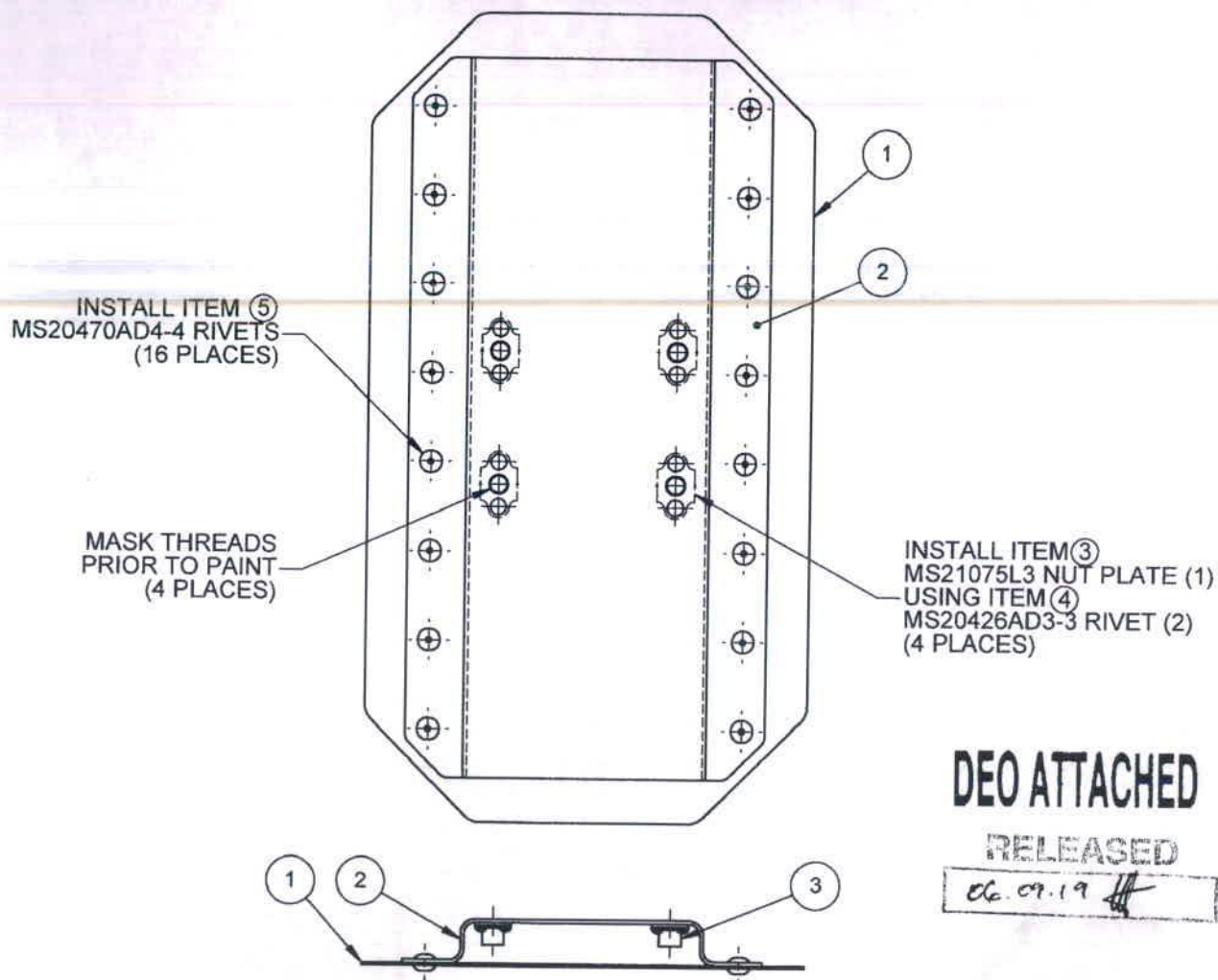
SHOP
RETURN
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *54297*
PH 10-2-17

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|------------------------------|--------------------------------|--|------------------------|
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| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3303 | REV. B SHEET 2 OF 4 |
| DATE 06.08.17 | | TITLE HEAD REST | SCALE 1:2 |

**DEO ATTACHED****RELEASED**06.09.19 *[Signature]***D3303-043 BRACKET ASSEMBLY**

| ITEM | QTY -043 | P/N | DESCRIPTION |
|------|-------------|--------------|------------------|
| | X | D3303-043 | BRACKET ASSEMBLY |
| 1 | 1 | D3303-1 | PLATE |
| 2 | 1 | D3303-3 | HEAD REST |
| 3 | 4 | MS21075L3 | NUT PLATE |
| 4 | 8 | MS20426AD3-3 | RIVET |
| 5 | 16 | MS20470AD4-4 | RIVET |

NOTES:

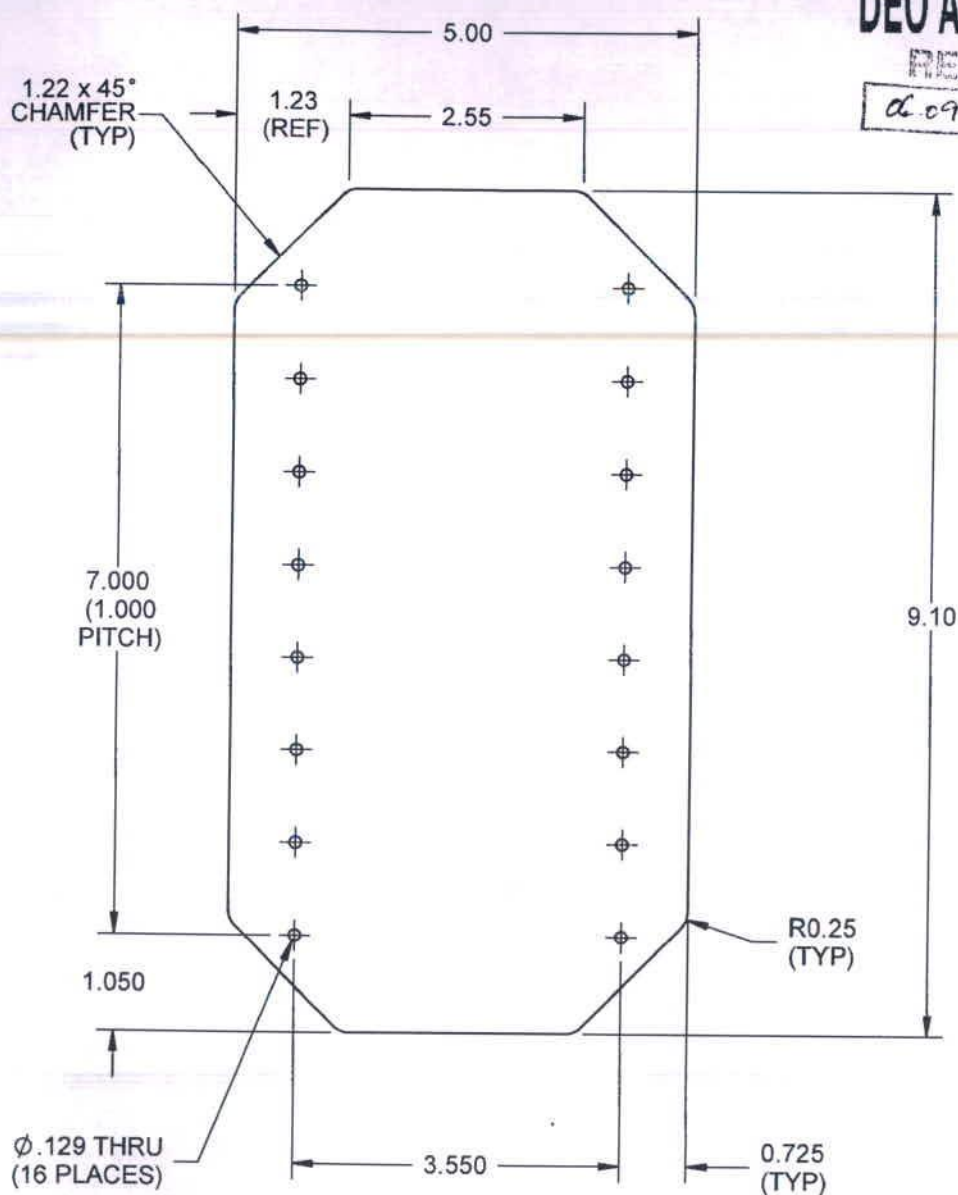
- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3303 | REV. B SHEET 3 OF 4 |
| DATE 06.08.17 | | TITLE HEAD REST | SCALE 1:2 |

**DEO ATTACHED****RELEASED**09.14 *[Signature]***D3303-1 PLATE****NOTES:**

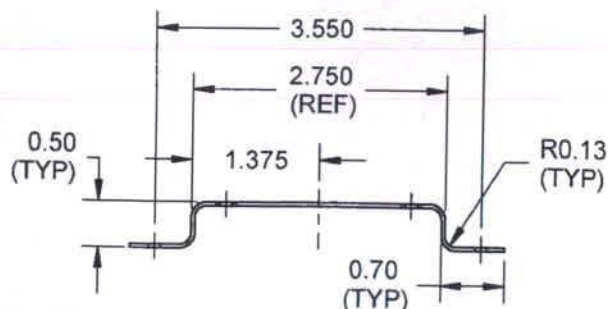
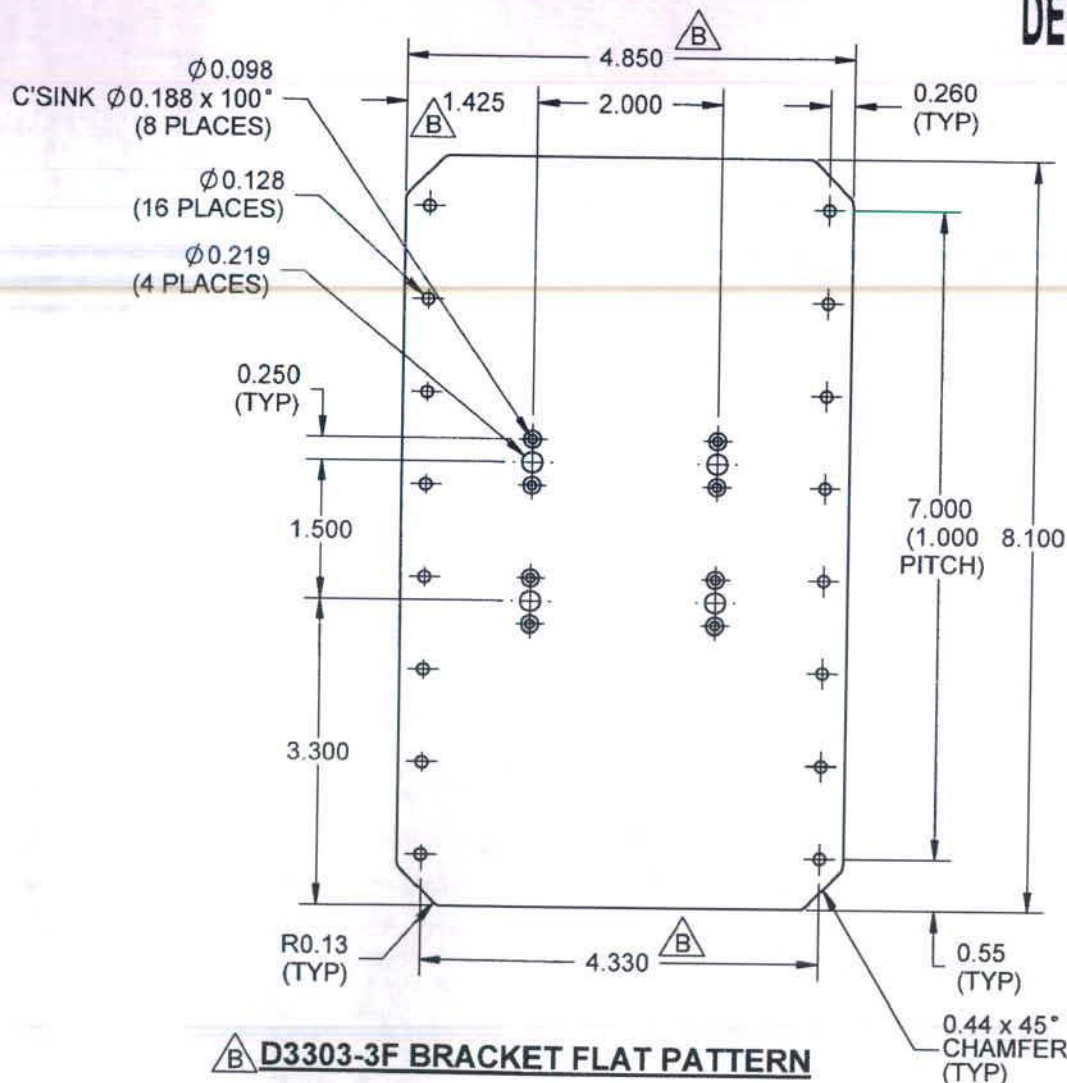
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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|------------------------------|--------------------------------|---|------------------------|
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| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3303 | REV. B SHEET 4 OF 4 |
| DATE 06.08.17 | | TITLE HEAD REST | SCALE 1:2 |

DEO ATTACHED**D3303-3 BRACKET BEND DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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| | | | | | | | |
|----------------------|---------------------|------------------------|---|----------------------|-------------------------|---------------------------|--------------|
| DRAWING NO. D3303 | TITLE HEAD REST | REV. B | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3303-B-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN AJS | CHECKED <i>h</i> | MFG. APPR. <i>h</i> | APPROVED <i>h</i> | DE APPR. <i>h</i> | | | |
| DATE 08.10.15 | DATE 08.10.15 | DATE 08/10/16 | DATE 08/10/16 | DATE 08/10/16 | | | |

SHEET 1 ADD 1300L ADHESIVE BY 3M TO NOTE 1 AS FOLLOWS:

IS:

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 OR 1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

WAS:

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

w/o 56297

SEE NCR 08-069 FOR FURTHER DETAILS

RELEASED
08/11/16

